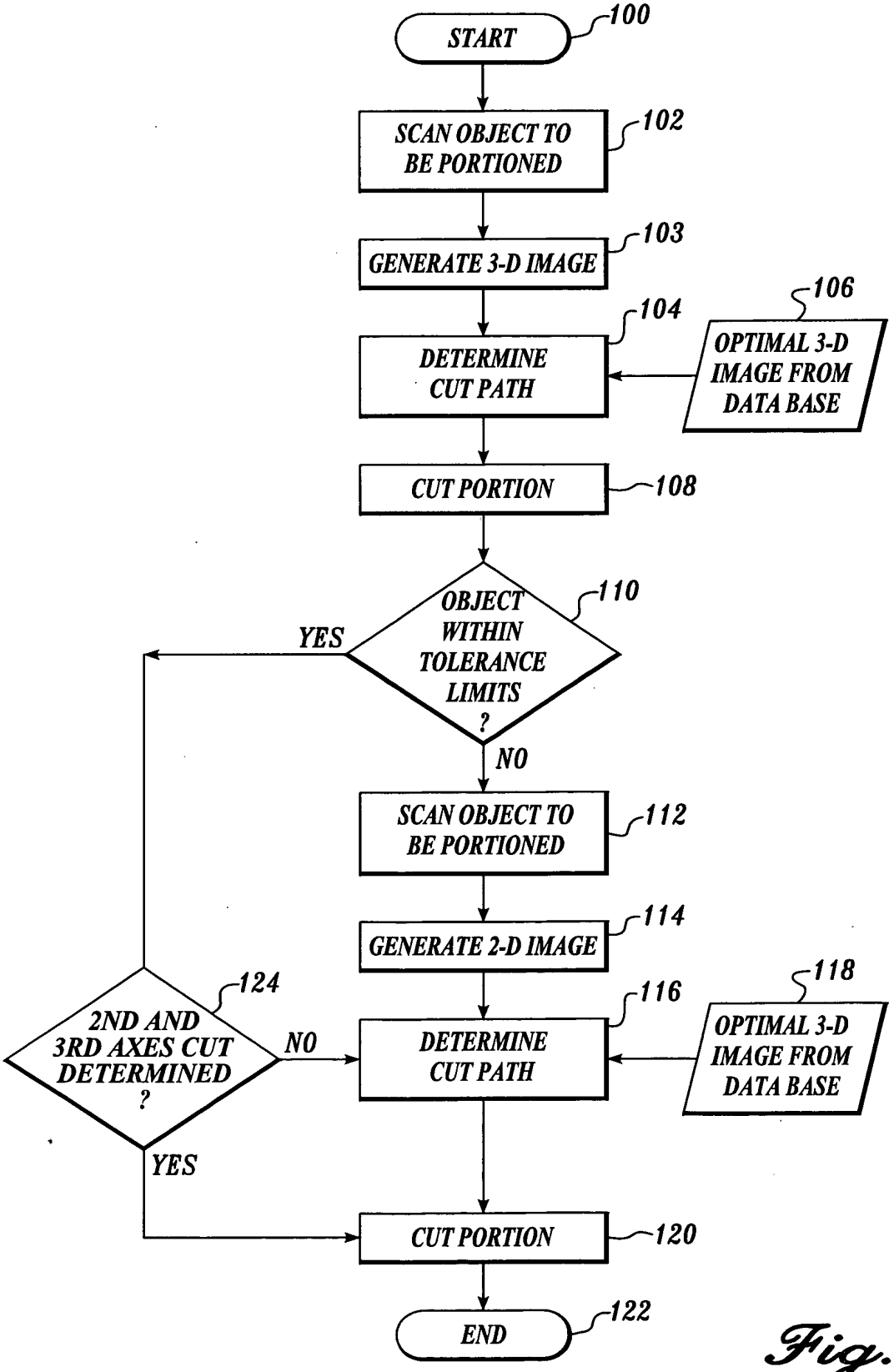
START
100
SCAN OBJECT TO BE PORTIONED
102
GENERATE 3-D IMAGE
103
DETERMINE CUT PATH
104
OPTIMAL 3-D IMAGE FROM DATA BASE
106
CUT PORTION
108
OBJECT WITHIN TOLERANCE LIMITS ?
110
YES
NO
SCAN OBJECT TO BE PORTIONED
112
GENERATE 2-D IMAGE
114
2ND AND 3RD AXES CUT DETERMINED ?
124
NO
DETERMINE CUT PATH
116
OPTIMAL 3-D IMAGE FROM DATA BASE
118
YES
CUT PORTION
120
END
122

Fig. 1

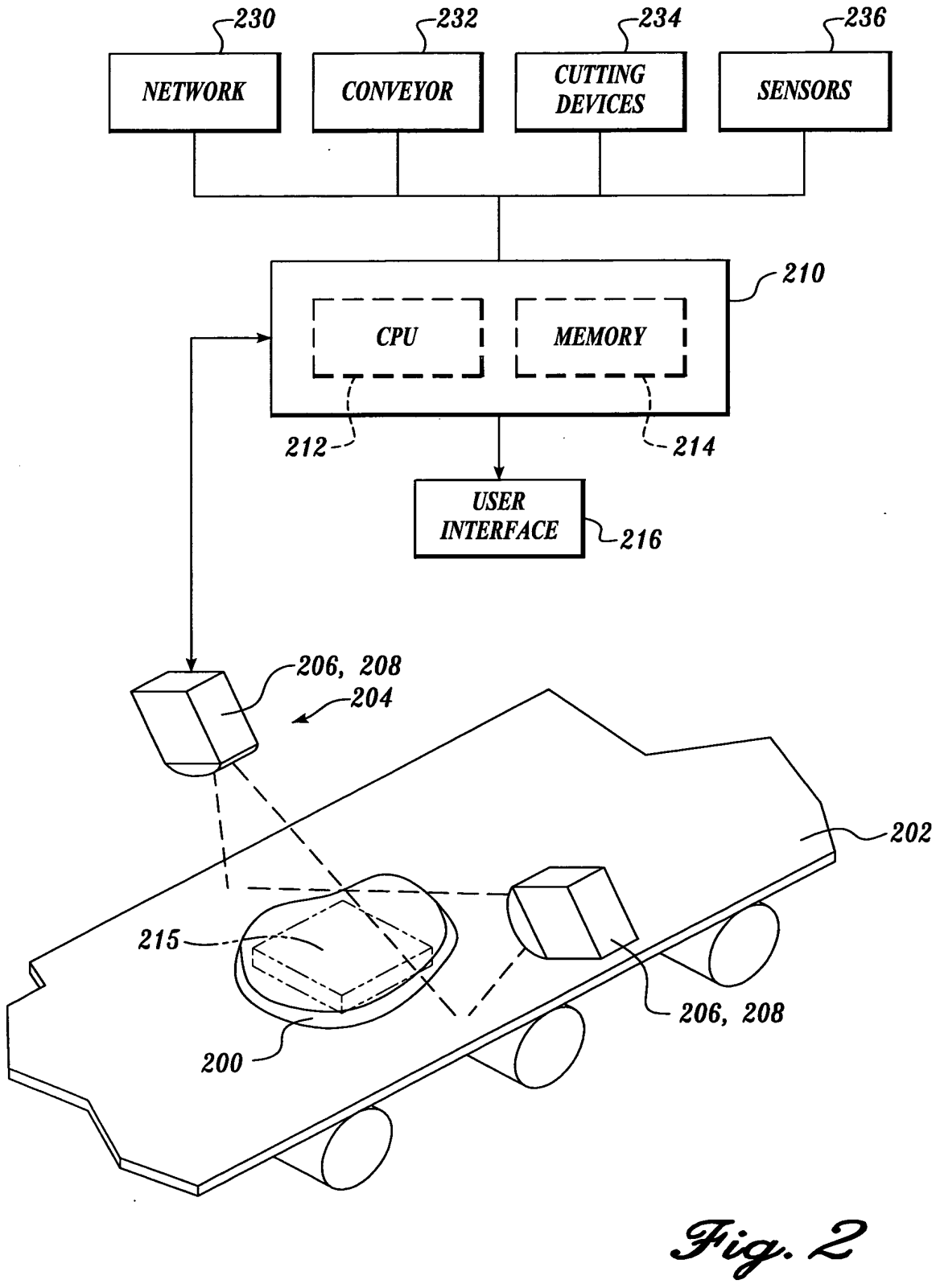
230
NETWORK
232
CONVEYOR
234
CUTTING DEVICES
236
SENSORS
210
CPU
MEMORY
212
214
USER INTERFACE
216
206, 208
204
202
215
206, 208
200

Fig. 2

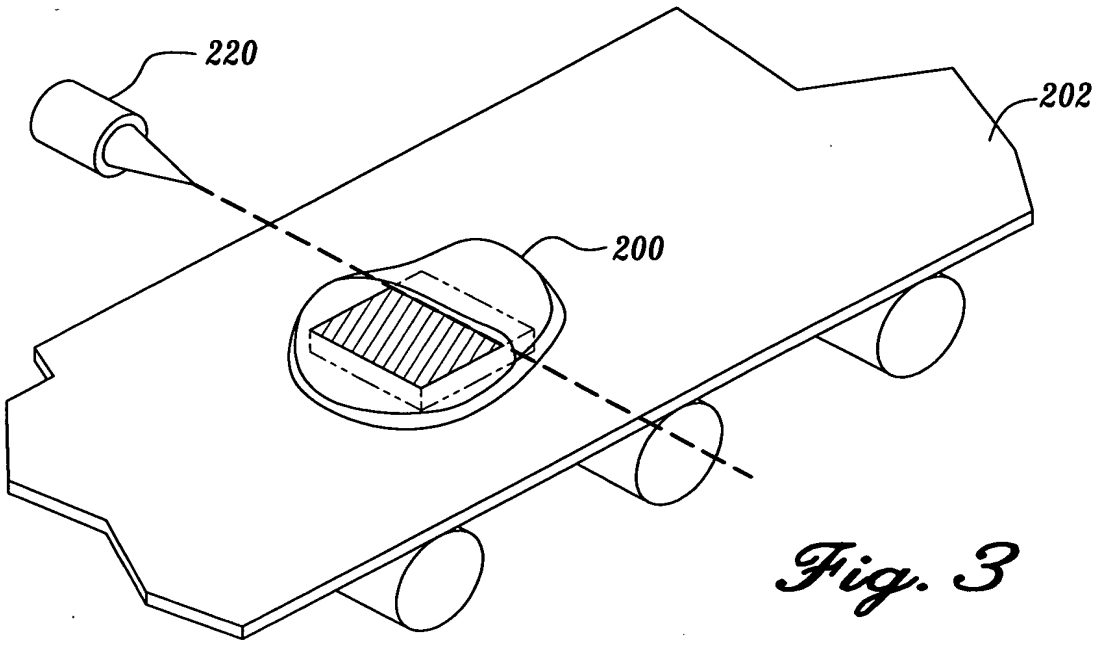

Fig. 3

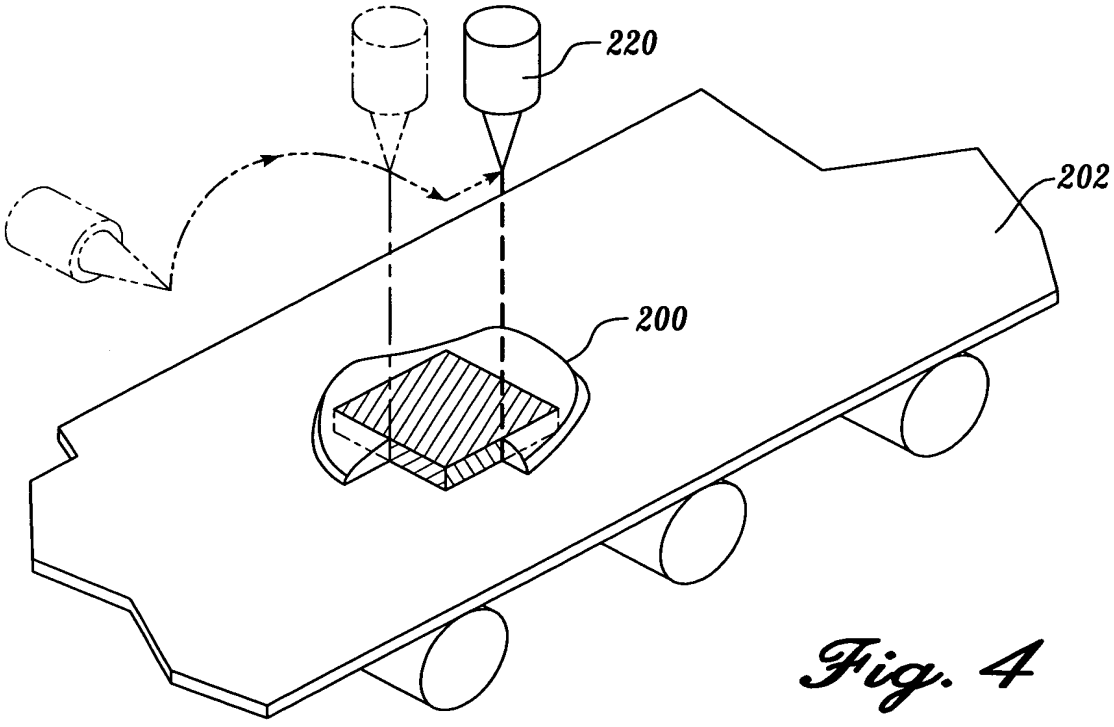

Fig. 4

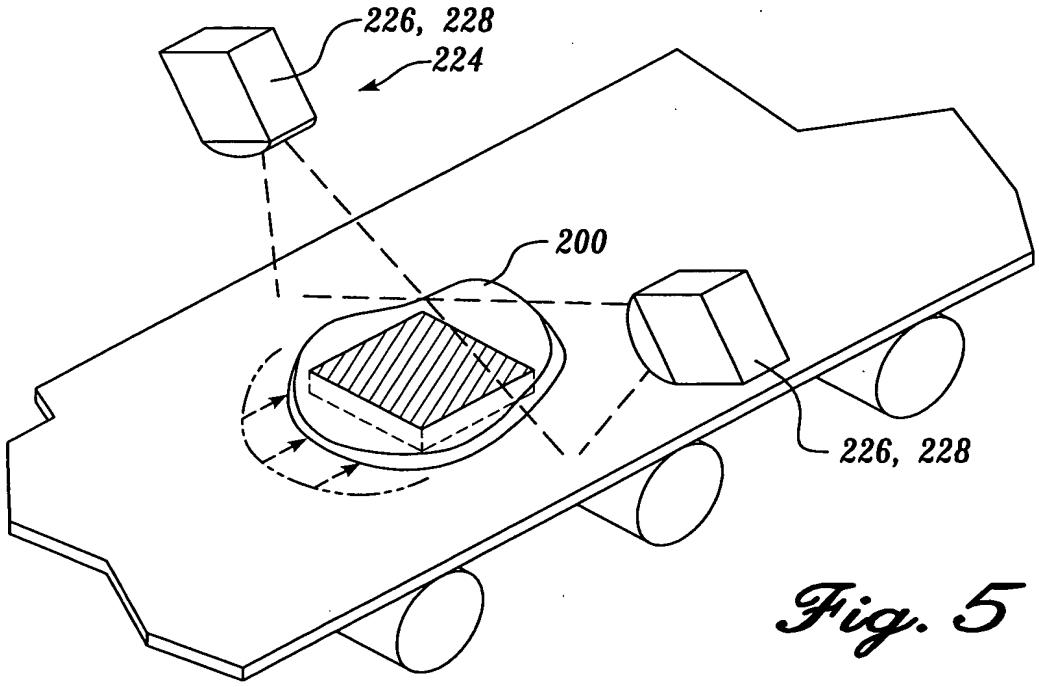

Fig. 5

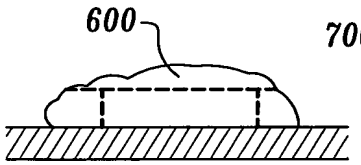

Fig. 6

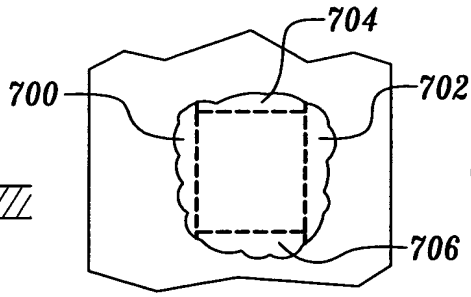

Fig. 7

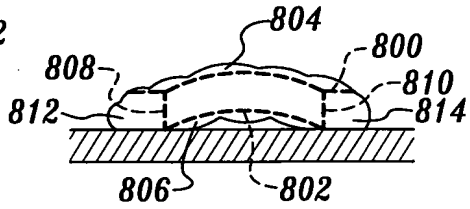

Fig. 8

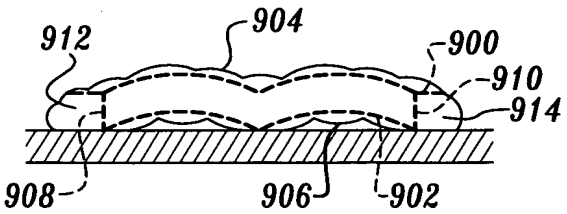

Fig. 9

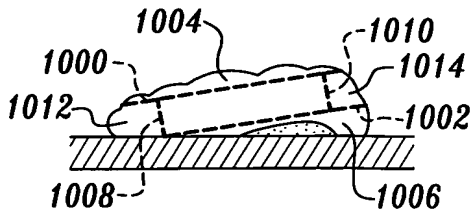

Fig. 10

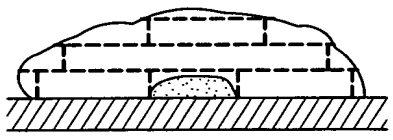

Fig. 11

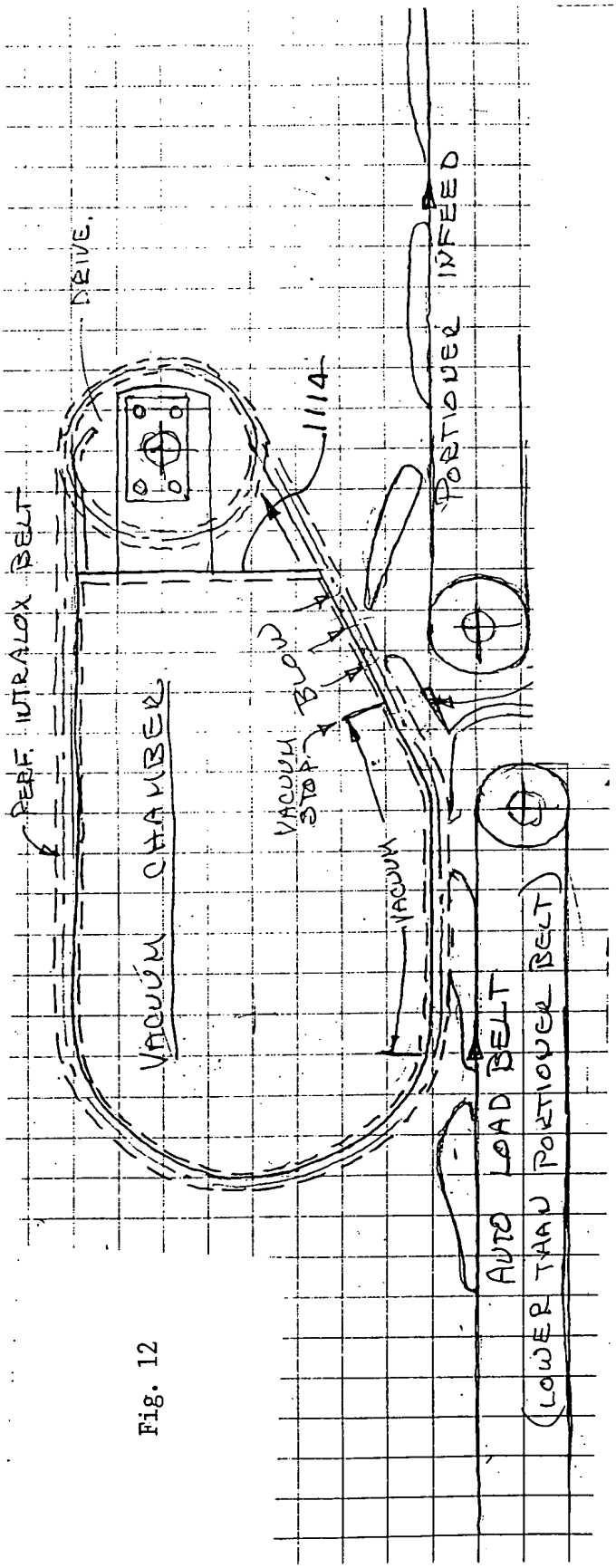
DRIVE
PERF. UTRALOX BELT
VACUUM CHAMBER
1114
VACUUM BLOW
VACUUM
PORTIONER INFEED
AUTO LOAD BELT
(LOWER THAN PORTIONER BELT)

Fig. 12